

CLAIMS:

1. A method for the preparation of three-dimensional casting skins having a leather-like surface, characterized in that

the porous surface of a vacuum tool having the geometry of the three-dimensional molded part is introduced into a pulp which contains leather fibers, suspending agents, binders and optionally usual additives;

leather fibers and binder are deposited in the desired layer thickness on the surface by applying a vacuum in the vacuum tool;

followed by transferring the surface to a press tool to densify the leather fiber layer, optionally followed by surface profiling and partial or complete drying, optionally followed by drying in one operation, followed by providing the surface with a finish.
2. The method according to claim 1, characterized in that the porous surface of a sintered powder metal, a ceramic, a metal foam, a plastic foam or a screen is employed.
3. The method according to claim 1, characterized in that an aqueous pulp is employed.
4. The method according to claim 1, characterized in that a pulp is employed which contains leather fibers in an amount of from 0.1 to 10% by weight, especially in an amount of from 0.5 to 2% by weight.
5. The method according to claim 1, characterized in that the surface properties of the finish and/or of the leather fiber material are achieved by embossing, grinding, plasma treatment, corona treatment, sand blasting or shot blasting.

6. The method according to claim 1, characterized in that a pulp is employed which contains leather fibers of a length of from 0.1 to 15 mm, especially of a length of from 0.3 to 3 mm.
7. The method according to claim 1, characterized in that a pulp is employed which contains a thermoplastic and/or thermosetting binder, especially selected from natural rubber, polyurethane, polyacrylates, dispersions of acrylic esters, vinyl esters and isobutylene polymers and mixed polymers, or a vinyl acetate.
8. The method according to claim 1, characterized in that a pulp is employed which contains a binder in an amount of from 10 to 50% by weight, especially in an amount of from 15 to 30% by weight, respectively based on the dry weight.
9. The method according to claim 1, characterized in that the leather fibers are applied in a dry layer thickness of from 0.1 to 6 mm, especially from 0.1 to 2 mm, more especially from 0.3 to 0.6 mm.
10. The method according to any of claims 1 to 9, characterized in that the drying step comprises the polymerization, polycondensation, cross-linking and/or film forming of the binder.
11. The method according to claim 1, characterized in that a mold with mobile slides for forming undercuts is employed.
12. The method according to claim 1, characterized in that the leather fiber layer is released from the surface of the vacuum tool and provided with a foam backing or injection-molded backing.
13. The method according to claim 1, characterized in that the finish is coated and/or sprayed onto the leather fiber layer and/or onto the surface of the mold.

14. The method according to claim 1, characterized in that a pulp is employed which further contains non-collagenous fibers, especially cellulose, cotton and/or plastic fibers.
15. A three-dimensional molded part having a leather-like surface and obtainable by a method according to any of claims 1 to 14.
16. The molded part having a leather-like surface according to claim 15, comprising furniture, clothing, accessories, installation parts, veneers and trims, especially for the automotive field.
17. The molded part according to claim 16, characterized in that said parts in the automotive field are floor trims, pillar trims, trunk trims, door trims, dashboard trims, switches, gearshift levers, seat cushions, seat rests, door-knobs and steering wheel covers.